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D350-591-312
Job Sheet 197605



SPTX
392

Non-Airbus

Part No: D350-591-312

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/11/19

Job Tracking No:

Due Date: 8/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	8/5/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		<i>CC</i>
							Large Fab - 8		
							Large Fab - 9		
120	QC 9	10 pcs	8/5/19		0.00	0.00	Large Fab - 11 (Various)		
							QC 9 - 10		
							QC 9 - 18		<i>BE</i>
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
130	QC 5	10 DCS	8/5/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		<i>BE</i>
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Container No: S201901



Part: D350-591-312

Job No: 197605

Serial No/Batch: S201901

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 1

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140 Handfinish - 1-1 Chemical-B4B	10 pcs	8/5/19	0.00	1.87	QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	10 pcs	8/5/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
180 Large Fab - Steps - 2 - B4B	10	8/5/19	0.00	10.00	Large Fab - 1 - B4B	

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220	Powdercoat - 1 White Gl(A)- B4B	10 pcs	8/5/19	0.00 2.98	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
230	Handfinish - 3-1- WingWalk- B4B	10 pcs	8/5/19	0.00 1.87	Handfinish - 3 - 1 - B4B	AL 14-8-6
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
240	QC 3	10 pcs	8/5/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	DAS 61 9-89
					QC 3 - 61	
					QC 3 - 81	
250	Packaging 1-1 - Pick Kit - B4B	10 pcs	8/5/19	0.00 0.00	Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	

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Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg
 Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush
 120 - QC9- Inspect visual per QSI004- Fusion Welds
 130 - QC5- Inspect part completeness to step on W/O
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - QC7-Inspect Chemical Conversion Coat
 180 - Weld per dwg A/R Aluminum rod Batch: _____ 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
 190 - QC10- Inspect visual per QSI004- ground welds
 200 - QC5- Inspect part completeness to step on W/O
 210 - Chemical Conversion Coat per QSI005 4.1
 220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 14074 OVEN TEMPERATURE: 375
 FINISH TIME: 2:00PM
 230 - Wing Walk as per dwg QSI005 4.4 Batch _____
 240 - QC3- Inspect Part Finish
 250 - pick kit
 260 - QC4- 100% Inspect kits for completeness
 270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109
 275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001
 280 - QC21- Final Inspection - Work Order Release

Job BOM

01180

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5198236
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5199742
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	5200437
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5201335
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5183580
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5196058
AN3-35A	Bolt	6 20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B ✓	5196190 ✓
AN4-13A	Bolt	2 80 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5207521 ✓
AN5-36A	Bolt	6 20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5194078 ✓
D2230-3	Mounting Lug	12 40 pcs (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5182242 ✓
D2618	Bushing	6 20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5211371 ✓
D2856-400-720	Abrasion Strip 4" X 7.20"	6 20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5187397 ✓
D3236-1	Mounting Lug	6 20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5202535-5118822-5169306 ✓
D3278-041	Support Assembly	3 10 pcs (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5204283 ✓
MS21042L3	Nut	6 20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5192449 ✓
MS21042L4	Nut	2 80 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5208332 ✓
MS21042L5	Nut	6 20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5201031 ✓
NAS1149D0363J	Washer	12 40 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5145362 ✓
NAS1149D0463J	Washer	48 160 Ea (16 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5174286 ✓
NAS1149D0563J	Washer	12 40 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B ✓	

DSI 4410011 x 1

5194395

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	39	0
	D3219-1	20	9	0
	D3272-1	10	10	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	2	0
	D3066-1	20	43	0
	MS20600-AD4W4	160	2,096	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	366	0
	AN4-13A	80	1,446	0
	AN5-36A	20	212	0
	D2230-3	40	775	0
	D2618	20	218	0
	D2856-400-720	20	28	0
	D3235-1	20	329	0
	D3278-041	10	3	0
	MS21042L3	20	1,099	0
	MS21042L4	80	2,008	0
	MS21042L5	20	401	0
	NAS1149D0363J	40	1,480	0
	NAS1149D0463J	160	3,292	0
	NAS1149D0563J	40	2,178	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
Part No. _____	Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	
	Use-as-is ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	
		Skid-tube ☐		Quality ☐	
		Machining ☐			
		Large Fab ☐			
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
		MRB (QS1042)			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step - High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step - High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step - Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step - Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step - High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step - High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
						D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4		D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-100-720	ABRASION STRIP
2	2	2	2	2	2	D3215-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.